



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D212-664-201TRN
Job Sheet 173485



Part No: D212-664-201TRN

Job Qty: 1 ea

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/16/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 08-03-06 new issue DD verified by:ec IPP Rev B 08.04.02 Removed polish EC verified DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/15/18	3/15/18	0.00	0.00	Start Up Crosstubes-2		PMP
100	Mori Seiki	1 pcs	3/15/18	3/15/18	0.00	1.33	Mori Seiki TL-40		PMP
110	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC1 QC2		PMP
120	Mori Seiki	1 pcs	3/15/18	3/15/18	0.00	1.33	Mori Seiki TL-40		PMP
130	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC1 QC2		PMP
140	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC8		PMP
145	Crosstubes	1 pcs	3/15/18	3/15/18	0.00	0.25	Crosstubes-2		DEB
150	HandFXtube	1 pcs	3/16/18	3/16/18	0.00	0.25	Crosstubes-3		DEB 18-05-01
160	QC	1 pcs	3/16/18	3/16/18	0.00	0.00	QC7-1		W
170	Packaging	1 pcs	3/16/18	3/16/18	0.00	0.00	Packaging3-1		W
180	QC21-SA	1 Ea	3/16/18	3/16/18	0.00	0.00	QC21		MAY 15 2018

Part Op 100 - 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114 2-Turn first side as per Folio FA114
 Descriptions: 120 - 1-Turn second side as per Folio FA114
 145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
 150 - 1- handfinish X-TUBE INSIDE AND OUT
 170 - Identify and stock in kanban rack Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6006-129	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6006-129	1	71	0

B123 969

Part Specifications

Specifications could not be found.

Plex 3/2/18 10:43 AM Dart.Gagnon.Michelle



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Container No: S050593



Part: D212-664-201TRN

Job No: 173485

Serial No/Batch: S050593

Revision:

Inspector:

Date: 03/13/19

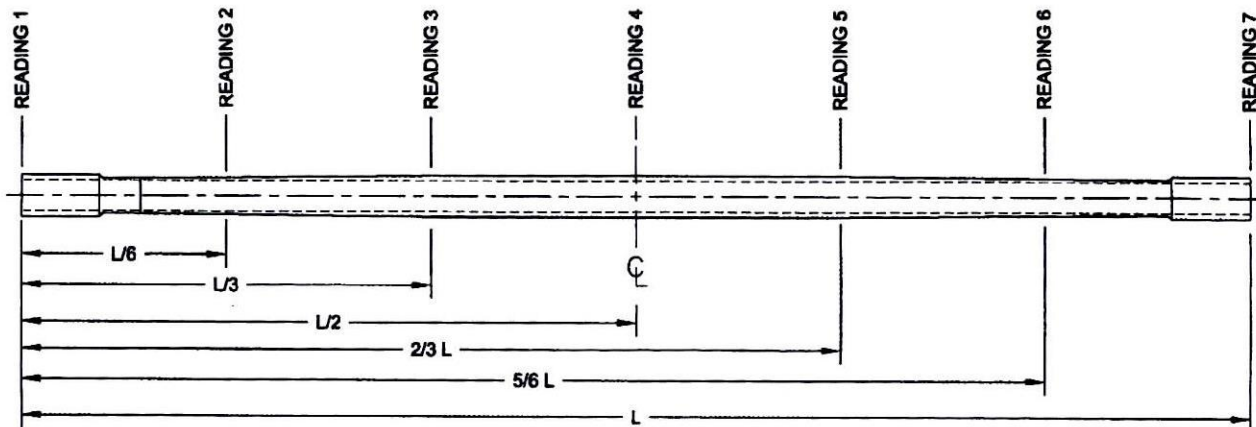
DART AEROSPACE LTD	Work Order:	173485
Description: Crosstube Assembly (205/212 High Aft)	Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: E		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.200	✓		VERN 08	
	R0.063	+/-0.010	.063	✓		RG	
	2.990	+0.005/-0.000	2.993	✓		VERN 08	
	5.237	+/-0.030	5.233	✓		"	
	2.600	+0.005/-0.000	2.605	✓		RLM 2"-3" 04	
	2.686	+0.005/-0.000	2.6905	✓		"	
	2.770	+0.005/-0.000	2.775	✓		"	
	2.854	+0.005/-0.000	2.859	✓		"	
	2.938	+0.005/-0.000	2.943	✓		"	
	3.021	+0.005/-0.000	3.026	✓		RLM 3"-4" 05	
	3.133	+0.005/-0.000	3.137	✓		"	
	3.179	+0.005/-0.000	3.183	✓		"	
	.500	±.01	.500	✓		RG	
	.063	±.01	.063	✓		RG	
	0.200	+/-0.010	.200	✓		VERN 08	
	R0.063	+/-0.010	.063	✓		RG	
SIDE B	2.990	+0.005/-0.000	2.993	✓		VERN 08	
	5.237	+/-0.030	5.239	✓		"	
	2.600	+0.005/-0.000	2.605	✓		RLM 2"-3" 04	
	2.686	+0.005/-0.000	2.691	✓		"	
	2.770	+0.005/-0.000	2.775	✓		"	
	2.854	+0.005/-0.000	2.859	✓		"	
	2.938	+0.005/-0.000	2.943	✓		"	
	3.021	+0.005/-0.000	3.026	✓		RLM 3"-4" 05	
	3.133	+0.005/-0.000	3.137	✓		"	
	3.179	+0.005/-0.000	3.183	✓		"	
	124.362	+/-0.020	124.360	✓		TAP	
	.500	±.01	.500	✓		RG	
	.063	±.01	.063	✓		RG	

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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L = 0"	399	412	409	399	.013	0.062"
READING 2 L = 20.73	342	318	308	336	.034	
READING 3 L = 41.45	502	482	482	504	.022	
READING 4 L = 62.18	528	514	523	542	.028	
READING 5 L = 82.91	489	489	492	504	.020	
READING 6 L = 103.69	324	312	324	341	.029	
READING 7 L =	390	391	419	419	.029	

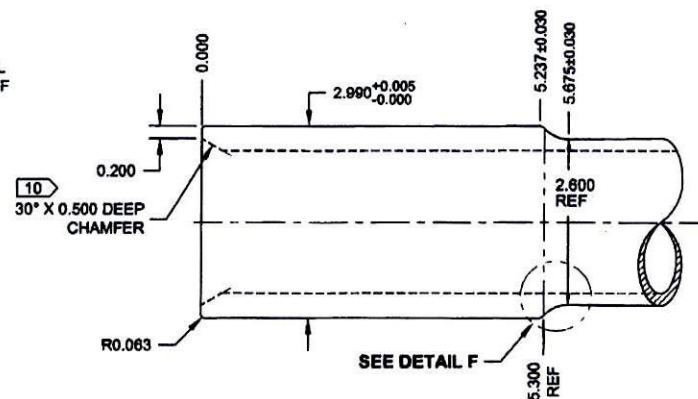
Calibration Result

Actual Block Thickness: 300-900

Sitiescan 250 Measured Thickness: 300 500

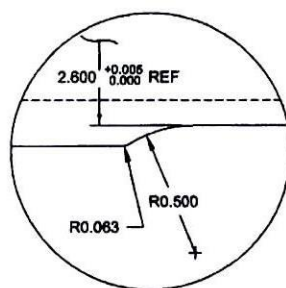
Measured by: PMP	Audited by: JW	Preliminary Approval: *
Date: 2018-03-13	Date: 18-05-27	Date:

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	
D	10.08.03	Dimension 124.362 was 124.36	KJ	
E	12.06.04	Wall thickness form added	KJ	
F	15.03.03	Dwg Rev updated	KJ	

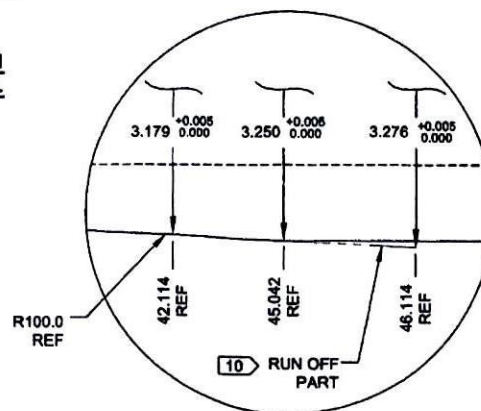


MAR 02 2018

RELEASE
2014-05-26



D212-664-241TRN
TURNING DETAIL



DETAIL E:
TAPER RUN-OFF
NOT TO SCALE

DESIGN	<i>92</i>	DART AEROSPACE LTD	
DRAWN	<i>92</i>	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	<i>SW</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>SW</i>	D212-864-241	SHEET 5 OF 5
APPROVED	<i>SW</i>	TITLE	SCALE
DE APPR.	<i>SW</i>	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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